

Work Order ID 50007 - 2

July 2, 2009 3:26:42 PM



54
SPIL 4x

Page 1

Item ID: D205-523-043

Accept



Setup Start



Revision ID: N/A

Stop



Item Name: Slide Bar Assembly

Start Date: 07/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D205-523-043

50

09/07/22

5

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> 8 07/07/22

5

Work Order ID 50007

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Item ID: D205-523-043

Accept



Setup Start



Revision ID: N/A

Item Name: Slide Bar Assembly

Stop



Start Date: 07/08/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/7/22 SQ

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/22

MF 09-07-22

Picklist Print

July 2, 2009 3:26:41 PM

Work Order ID: 50007

Parent Item: D205-523-043RevN/A

Parent Item Name: Slide Bar Assembly

Comments:

Start Date: 07/08/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3011-1RevA

Manufactured

No

110

Each

1.0000

8.0000



Rappel

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

44842

1

AN960JD616L

Purchased

No

110

Each

308.0000

16.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

308

102630

2

109545

6

111819

300

9/17/20

102630
109545
111819

82

Picklist Print

July 2, 2009 3:26:41 PM

Work Order ID: 50007

Parent Item: D205-523-043RevN/A

Parent Item Name: Slide Bar Assembly


Start Date: 07/08/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6 		Purchased	No			110	Each	803.0000	16.0000		9/7/20	SY
Nut												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

803

105077

22

110002

275

111548

100

111578

400

19099

6

110

Each

10.0000

16.0000

33116



Stud Fitting

Purchased

No

110002 (10) + 24

19099 (5)

9/7/20 SP

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

10

110694

10

110

Each

10.0000

16.0000

D3012-1RevA



Decal

Manufactured No

110694 (8x)

9/7/20

SP

(8x)

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

10

47662

10

50508

Shop Packet Print

47662 (2)

50508

(14)

(x2)

July 2, 2009 3:26:41 PM

Picklist Print

July 2, 2009 3:26:41 PM

Work Order ID: 50007

Parent Item: D205-523-043RevN/A

Parent Item Name: Slide Bar Assembly


Comments:

Start Date: 07/08/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L6 		Purchased	No			110	Each	803.0000	16.0000		9/7/20	SK
Nut												

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

803

105077

22

110002

275

111548

100

111578

400

19099

6

110

Each

10.0000

16.0000

33116



Stud Fitting

Purchased

No

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

10

110694

10

110

Each

10.0000

16.0000

D3012-1RevA



Decal

Manufactured

No

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

10

47662

10

30508

Shop Packet Print

47662 (2)

30508 (17)

(21)

July 2, 2009 3:26:41 PM

Picklist Print

July 2, 2009 3:26:41 PM

Work Order ID: 50007

Parent Item: D205-523-043RevN/A

Parent Item Name: Slide Bar Assembly



Comments:

Start Date: 07/08/2009

Required Date: 07/17/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3012-3RevA		Manufactured	No			110	Each	32.0000	16.0000			
											9/1/20	SP
Decal												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

43757

20

44844

2

47661

10

43757 (13)

47661 (3) + 2x

D3012-5RevA

Manufactured

No

110

Each

1.0000

16.0000



Decal



9/1/20 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

44845

1

50173

(8X)

50173

(2X)

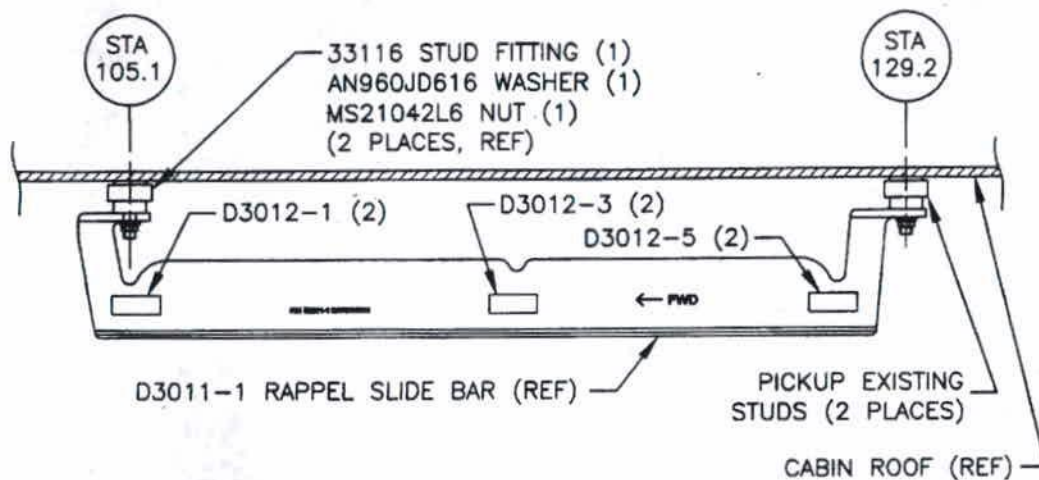


Figure 3 - Installation of D205-523-043 Slide Bar Assembly
(View Looking Inboard)

REFERENCE ONLY

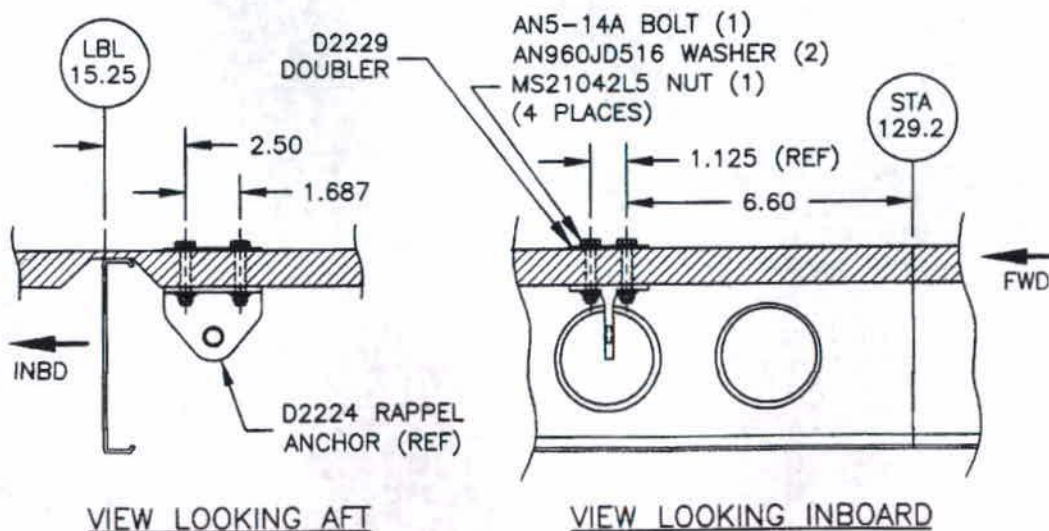


Figure 4 - D2224 Rappel Anchor Installation

#5007

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

5. PARTS LIST

-013	-043	Part No.	Description
X		D205-523-013	HELI-RAPPEL™ INSTALLATION
1	X	D205-523-043	SLIDE BAR ASSEMBLY
	1	D3011-1	RAPPEL SLIDE BAR
	2	33116	STUD FITTING
	2	MS21042L6	NUT (OR MS21042-6)
	2	AN960JD616	WASHER
	2	D3012-1	DECAL
	2	D3012-3	DECAL
	2	D3012-5	DECAL
1		D2224	RAPPEL ANCHOR
2		D2229	DOUBLER
4		AN5-14A	BOLT
8		AN960JD516	WASHER
4		MS21042L5	NUT (OR MS21042-5)

#50007

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	U	09-07-22	
2	GA	pull from stock 5x D205.523-011 4x B9866 1x B9865	U	09-07-22	
3	GA	remove stud fittings 33116 to use for D3011-1 Batches 6289; 6009; 6150 discard washers + nuts Adjust Acceptance —	SB	09/07/22	5
4	PK	Return D205-523-011's back to stock with Note "Stud Fittings 33116 missing"	SA	09/07/22	5
5	Q21	close rfd	SA	09/07/22	

H:\Forms\Quality Assurance\Approved QA\PPSHORT revA

Description: Slide Bar	Part Number:	D1005
Drawing: D1005 Rev. A	Qty:	15 (22)

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	CS	99.04.15	1522
2	METAL	Cut Blanks: 26.57" ^{2.80"} Material: 6061-T6 3" X 4" 1" Beam DM 99.05.12 Batch M6156	DD	99/05/12	22
3	HAAS	Machine as per folio D1005	DD	99/05/15	21
4	QC	Inspect Level 2	DD	99/05/15	21
5	METAL	Deburr Tumble Deburr any rough edges after tumbling	DD	99/05/15	21 (21)
6	METAL	Acid etch and alodine as per QSI 005 4.1	DD	99/05/16	21
7	QC	Inspect Level 7	3	99.05.26	21
8	PURCHASING	Issue P/O: 851520 Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3	SB	99/05.26	21
9	QC	Inspect Level 3	SB	99-06-4	21
10	STORES	Pick: Qty Part Number Description Batch 2 AN960JD616L Washer M2525 2 MS21042L6 Lock Nut M6069 2 33116 Stud Fitting M6283 M6009 M6150	SB	99-06-4	14+7
11	METAL	Assemble as per Dwg D1005	SB	99-06-4	14+7
12	QC	Inspect Level 5	SB	99-06-4	14+7
13	STORES	Identify and Stock	SB	99-06-9	14+7
14	EXPEDITING	Close Work Order 141.18	SB	99-06-10	14+7

Rev	Date	Change	Revised By	Approved
A	97.05.01	New Issue		
B	97.12.19	Added Assembly	BW	
C	98.05.08	Changed Nut	KB	
D	99.05.10	Re-format, Added Powder Coat	DM	DM

RELEASED
DM 99.05.10

INC NO. 205
COMPLETE DM 99.05.12

Blw 9806
9805 D205-52301
w

DM
99.06.15